

Work Order ID 57391

April 6, 2010 10:53:00 AM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 06/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

DT

Date: 10-4-06

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

005
5/10/05/05

CL 10/5/3 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod-Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

E: Date & initial all entries

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod

M113207

10-Grind welds flush as per Dwg D2750

M10/4/20

BE 10/04/21

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- scribe batch #.

BE 10/04/21

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

S 10/04/21

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S 10/04/21

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 - - AWM
10-4-21

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00 -



QC

Memo

0.00

Quality Control

1 11/10/14/21

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Skidtubes								
Skidtubes									
Skidtubes									
	Memo	0.00							
	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 batch: <u>M112429</u> exp. date: <u>10-8-20</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod batch: <u>M113207</u>								
	9-Grind welds flush as per Dwg D2750								
	10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750								

AWM 10-4-21

BE 10-4-22

10-4-22

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

12-Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

Handwritten: 104-28

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:45am
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:15am

Handwritten: 10604/28

Handwritten: 10

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

Handwritten: 7m, 10/04/30

Handwritten: 1X

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

220



HandFinish

HandFinishing

0.00

Memo

0.00

Install inserts as per dwg D2750

= 7 m-h 10/04/30

230



HandFinish

HandFinishing

0.00

Memo

0.00

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
batch: _____

N/A

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750

SIKA FLEX 241

BATCH: _____

EXP DATE: _____

M112429

10/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: _____

M114189

5-Coat all exposed fasteners with "LPS Procyon"
batch: _____

M104251

m-h

10/04/30

Dart Aerospace Ltd

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Required Date: 16/04/2010 Req'd Qty: 1.00




Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	810/04/30			40			
250  Packaging Packaging	Pick Kit Memo	0.00 0.00				10-5-35			
260  QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	810/05/03			40			

W/O:		WORK ORDER CHANGES					
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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
	LC 72								
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10-5-48

10/05/04
BS 10-5-04
(1)

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Picklist Print

April 6, 2010 10:53:04 AM

Page 1

Work Order ID: 57391

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

ALS4-1032-225

Purchased

No

220

Each

7,729.000 38.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

PK011

7729

110768

7729

230

Each

389.0000 34.0000

AN3C5A

Purchased

No



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST351

389

113121

10

114056

179

114108

100

114181

100

AN3C6A

Purchased

No



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST351

679

111982

679

m-h

38 x 16/04/29

34 x m-h
16/04/29

4x m-h
16/04/29

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 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

53.0000

4.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST344

51

111605

1

111649

50

AN8C35A

Purchased

No

230

Each

19.0000

1.0000



BOLT

M110847

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

19

110847

19

AN960C10L

Purchased

No

230

Each

0.0000

38.0000



washer

NAS1149C0332R

M114341

38x m-l

10/04/30

4x 10/04/2010

1x m-l

10/04/30

m-l

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Shop Packet Print

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 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased

No

230

Each

146.0000 1.0000



WASHER



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

146

110584 ✓

100

111424 ✓

46

Manufactured

No

230

Each

150.0000 8.0000

D2745



Bushing



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST023

150

52311 ✓

150

IX m-l 10/04/30

8X m-l 10/04/30

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Shop Packet Print

Page 3

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Start Date: 06/04/2010

Start Qty: 1.00

Required Date: 16/04/2010

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

27.0000

1.0000



Blade Fitting Assembly, RH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

7

52666

7

Main Warehouse

FP008

20

53918

20

D3492-041

Manufactured No

230

Each

42.0000

8.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

42

55446

42

D3492-043

Manufactured No

230

Each

42.0000

8.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

42

54682

42

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Shop Packet Print

Page 4

IX m-k
10/04/30

8x m-k
10/04/30

8x m-k
10/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 57391



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:J 06-03-29 As per Rev D EC

IPP Rev:K 06-07.13 As per dsi9343 EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

D3535-25

Manufactured No

230

Each

5.0000

1.0000



Wearshoe



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

56065

B56839

5

5

230

Each

12.0000

1.0000

D3536-25

Manufactured No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP10

54479

12

12

230

Each

51.0000

3.0000

D3537-1

Manufactured No



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

55465

B57511

51

51

1x m-h
10/04/30

1x m-h
10/04/30

3x m-h
10/04/30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 57391



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

302.0000 8.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST076

52693 ✓

302

302

230

Each

1,589.000 4.0000

D3672-1



Phenolic Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

47628 ✓

51674

52505

1589

89

500

1000

m-l

8X 10/04/30

m-l

4X 10/04/30

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 57391

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3791-1



Wearplate

Manufactured No 230 Each 18.0000 1.0000

Warehouse
Location

Main Warehouse

FP

55457

7

7

Main Warehouse

FP17

56299

11

11

D3793-1



Wearshoe

Manufactured No 230 Each 14.0000 1.0000

Warehouse
Location

Main Warehouse

FP18

51597

56300

14

2

12

10/04/30

IX m-1

10/04/30

IX m-1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57391



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3793-3

Manufactured No

230

Each

10.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

55458 ✓

10

10

230

Each

7.0000

1.0000

D3794-1

Manufactured No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

55459 ✓

7

7

230

Each

27.0000

1.0000

D3794-3

Manufactured No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

51907

Main Warehouse

FP18

56066 ✓

4

4

23

23

10/04/30

IX m-1

10/04/30

IX m-1

10/04/30

IX m-1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57391

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No 230 Each 878.0000 4.0000



NUT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST301

878

112314 ✓

878

MS21083C8

Purchased No

230

Each

50.0000

1.0000



NUT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST303

50

113845 ✓

50

NAS1611-010

Purchased No

230

Each

330.0000

8.0000



O-RING

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

330

110715 ✓

100

110915 ✓

230

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m-l
 4X 10/04/30
 10/04/30
 1X m-l
 8X m-l 10/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 57391

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

41.0000

8.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

113743

41

41

250

Each

99.0000

2.0000

AN8C21A

Purchased

No



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST345

111605

113558

99

49

50

250

Each

146.0000

2.0000

AN960C816L

Purchased

No



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

110584

111424

146

100

46

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57391

Parent Item: D350-636-012

Parent Item Name: Skidtube RH


Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

S D2741

 Blade, 350 Skidtube

Manufactured No 250 Each 11.0000 1.0000



10.5.38

Warehouse
Location
Loc Qty
Loc Code


Main Warehouse

ST466

11

51931

11

S D3493-1

 Washer

Manufactured No 250 Each 19.0000 2.0000



10.5.38

Warehouse
Location
Loc Qty
Loc Code


Main Warehouse

ST224

19

47710

19

S D3532-1

 Spacer

Manufactured No 250 Each 51.0000 2.0000



10.5.38

Warehouse
Location
Loc Qty
Loc Code

Main Warehouse

ST068

51

52321

51

2

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Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 57391

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-13



Phenolic Washer

Purchased No

250

Each

920.0000 2.0000



10-5-38

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST077

54363

920

920

250

Each

50.0000 2.0000



2 10-5-38

MS21083C8



NUT

Purchased No

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST303

113845

50

50

110

Each

5.0000 1.0000



2

D2600-3-BENT



Extrusion Bent

Manufactured No

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

LG

54402

5

5

B57538

1

DP 10-4-21

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 13

Work Order ID: 57391

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By:EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2744 Manufactured No 110 Each 42.0000 1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 42

47488 23

51922 19

D2739 Manufactured No 160 Each 2.0000 1.0000



350 I Beam

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 2

55986 2

D2743 Manufactured No 160 Each 138.0000 8.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 138

50281 50

52310 88

1 BE 10/04/21

DP 10-4-21

8 BE 10/04/22

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 57391



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3490-3

Manufactured No

160

Each

40.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

40

55010

40

D3490-1

Manufactured No.

160

Each

12.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

12

51932

12

4 BE 10/04/22

4 BE 10/04/22

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
1			1	D2750-4	SKIDTUBE WELDMENT, RH
	1			D3488-041	BLADE FITTING, LH
4	4	4	4	D3488-042	BLADE FITTING, RH
4	4			D3490-1	SPACER
		4	4	D3490-3	SPACER
8	8	8	8	D3490-5	SPACER
8	8			D3492-041	PLUG ASSEMBLY
		8	8	D3492-043	PLUG ASSEMBLY
1	1	1	1	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
3	3	3	3	D3536-25	GASKET
8	8	8	8	D3537-1	WEARPAD
1	1	1	1	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
- POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57391

10-4-06

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL) WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F
SHEET 1 OF 11
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

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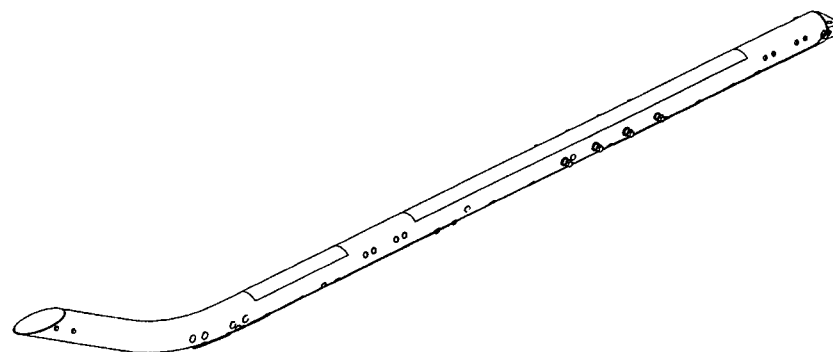
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

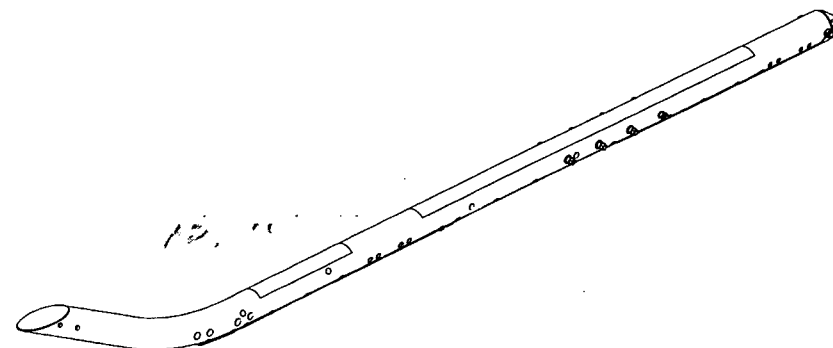
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

W/O 57391

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08.09.22.14

DESIGN	Per	DART AEROSPACE USA, INC.	
DRAWN	AM	PORT HADLOCK, WA	
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MFG. APPR.	SA	D2750	SHEET 2 OF 11
APPROVED	ME	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

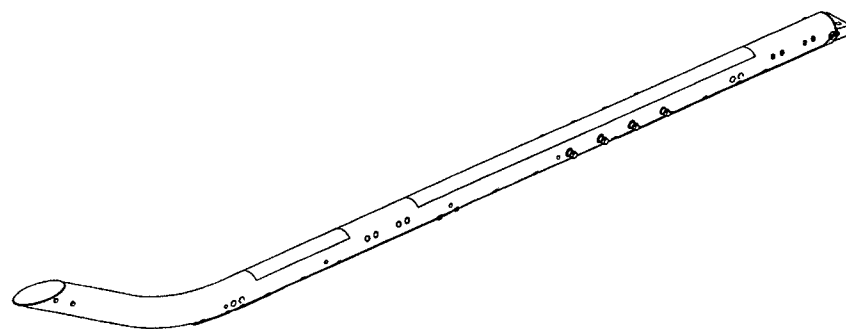
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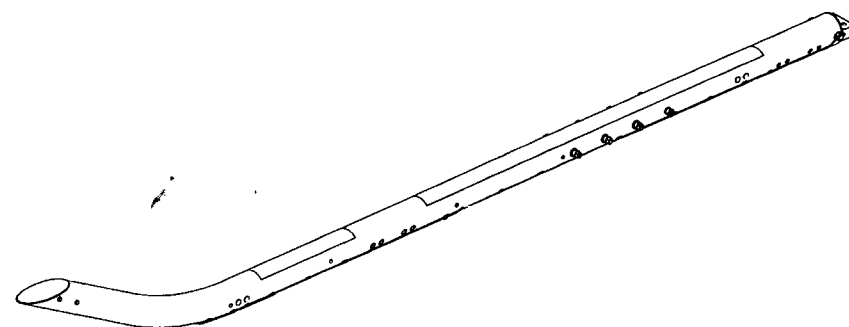
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

w/o 57391



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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APPROVED	10	TITLE	SCALE
DE APPR.	10	350 SKIDTUBE ASSEMBLY	NTS
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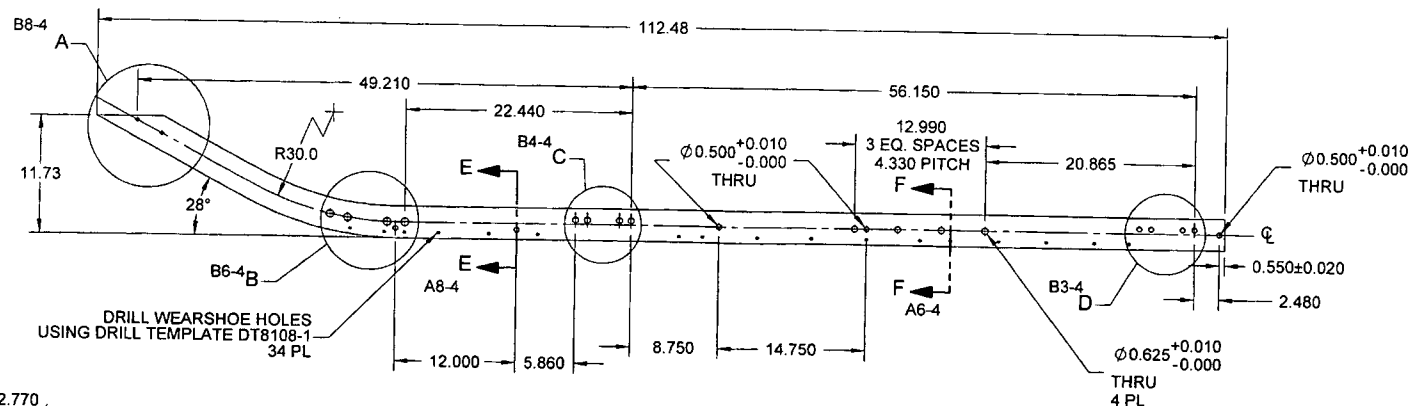
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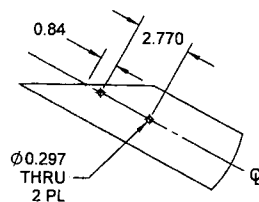
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

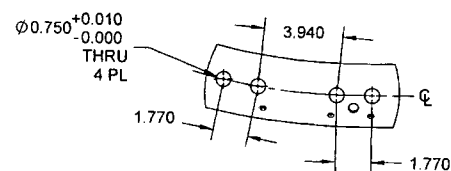
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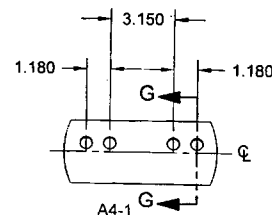
D2750-1 LH SKIDTUBE



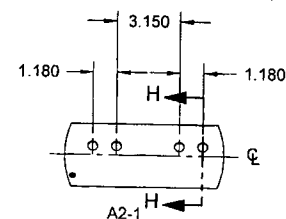
DETAIL A
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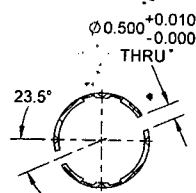
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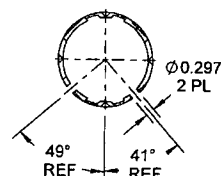
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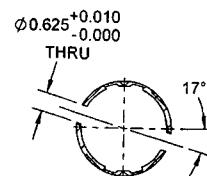
DETAIL D
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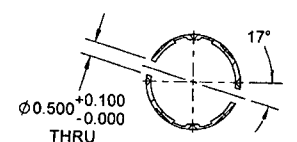
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

w/o 57391

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MFG. APPR.		SHEET 4 OF 11	
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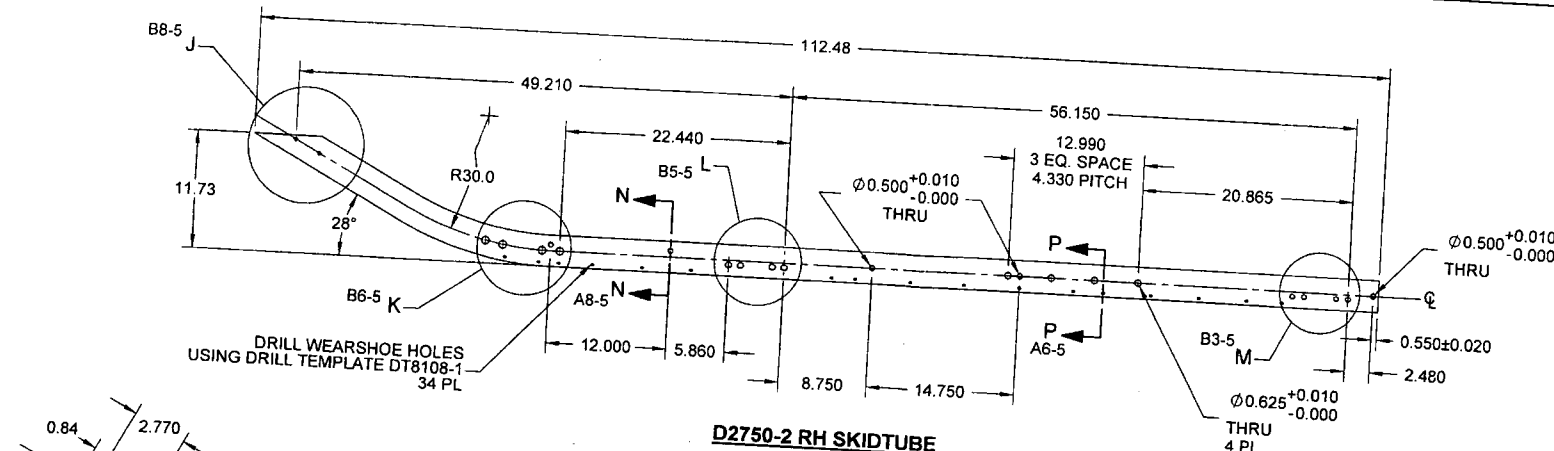
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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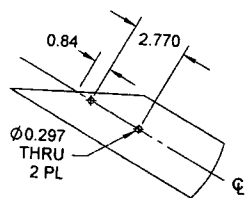
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

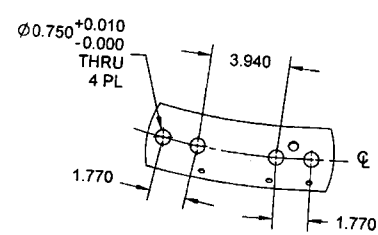


D2750-2 RH SKIDTUBE

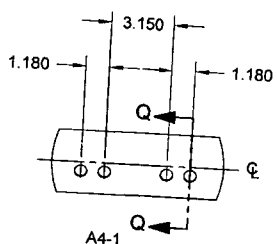
W/O 57391



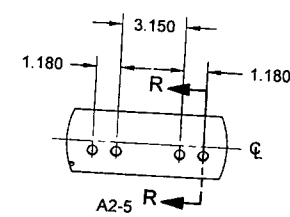
DETAIL J
SCALE 2X



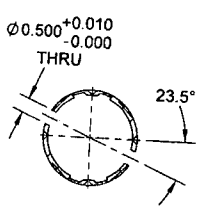
DETAIL K
SCALE 2X



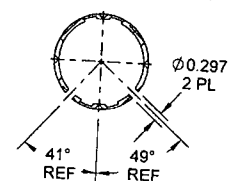
DETAIL L
SCALE 2X



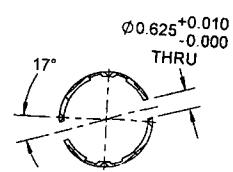
DETAIL M
SCALE 2X



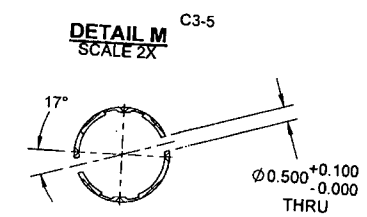
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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MFG. APPR.		D2750	
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DE APPR.		TITLE	
DATE		350 SKIDTUBE ASSEMBLY	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

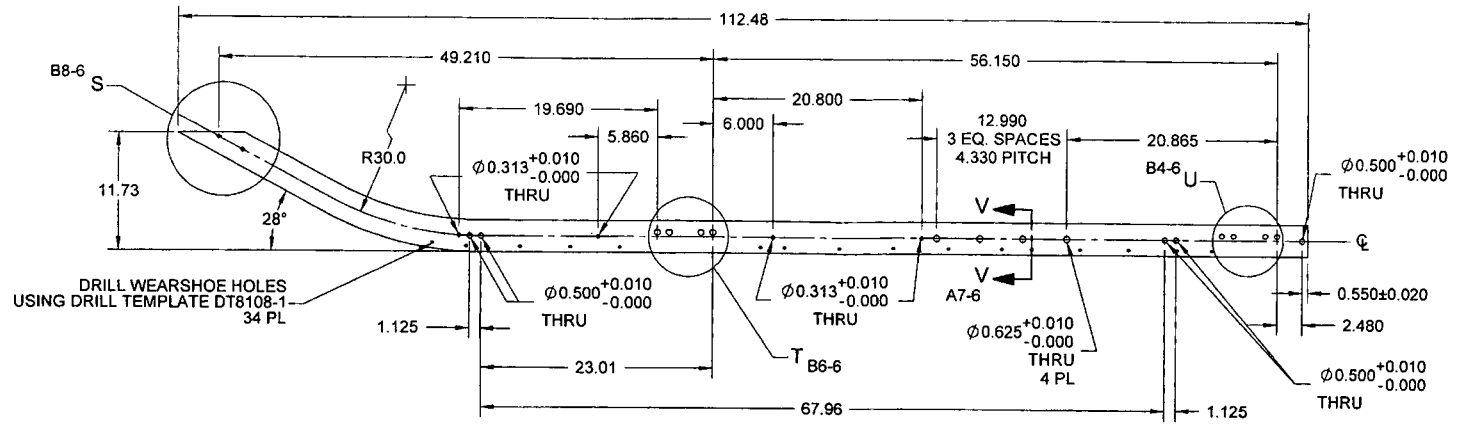
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

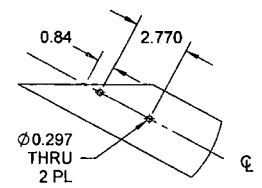
NOTE: Date & initial all entries

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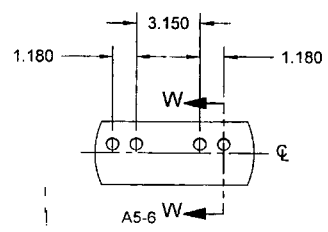


D2750-3 LH SKIDTUBE

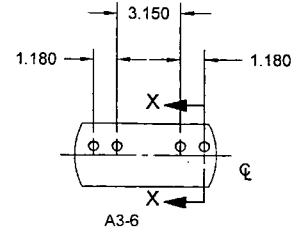
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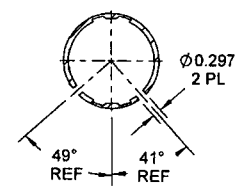
DETAIL S
SCALE 2X



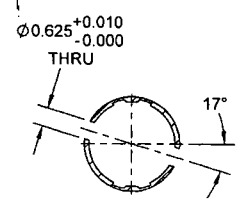
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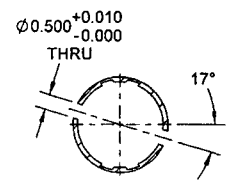
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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DESIGN		DART AEROSPACE USA, INC.
DRAWN		PORT HADLOCK, WA
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MFG. APPR.		REV. F
APPROVED		SHEET 6 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE NTS

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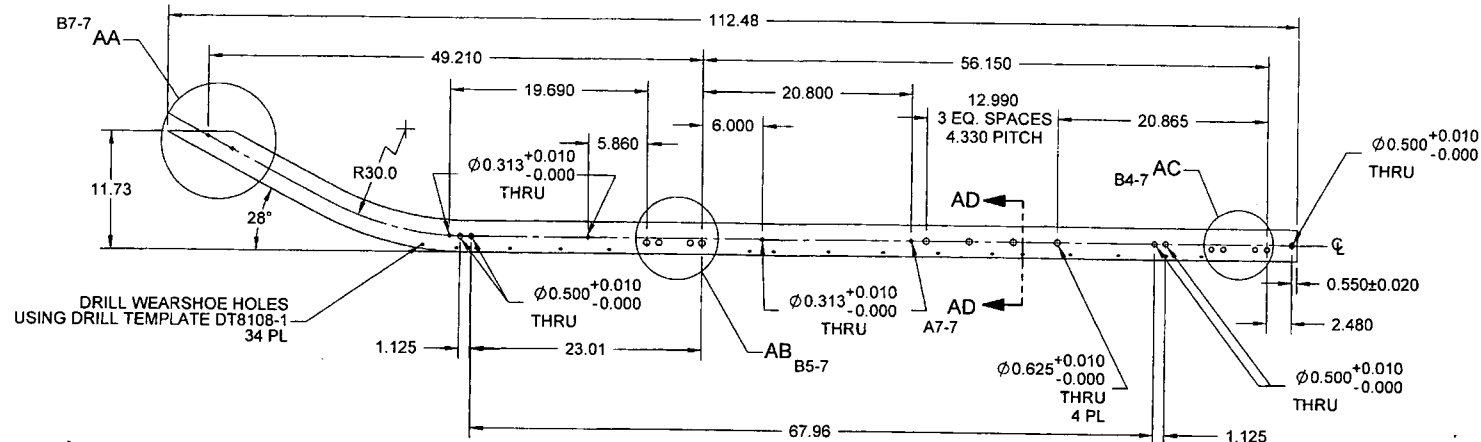
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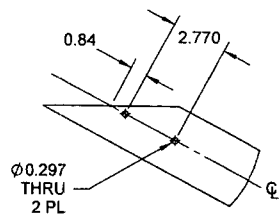
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

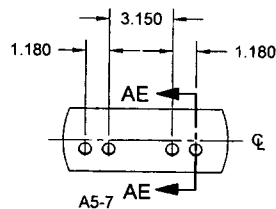
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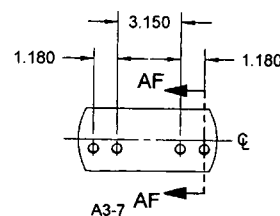
D2750-4 RH SKIDTUBE



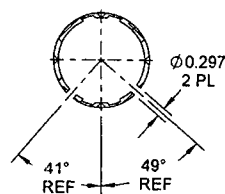
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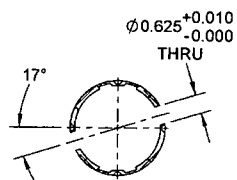
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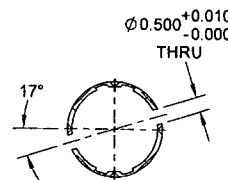
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

w/o 57391

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DESIGN	PA	DART AEROSPACE USA, INC.	
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MFG. APPR.	PA		SHEET 7 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

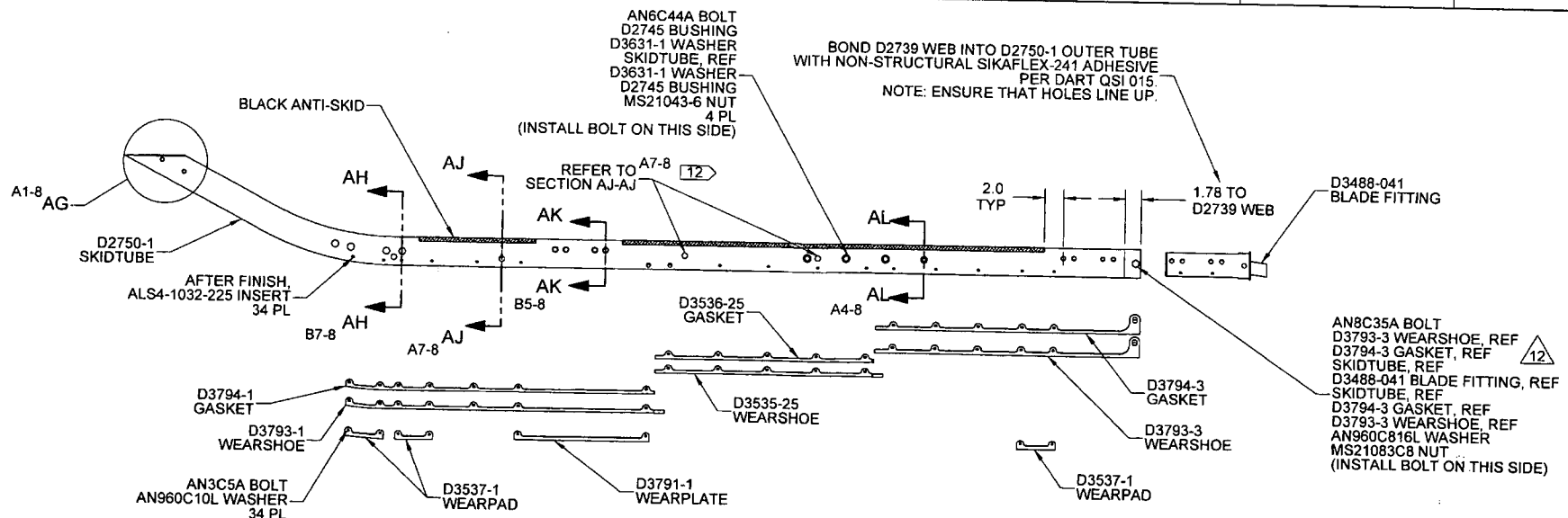
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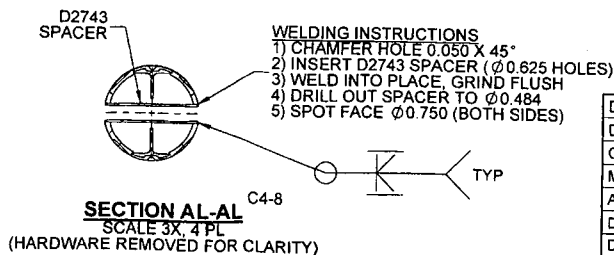
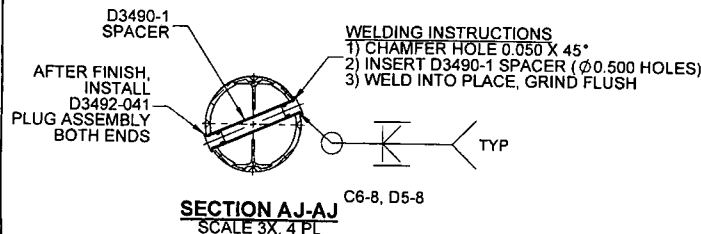
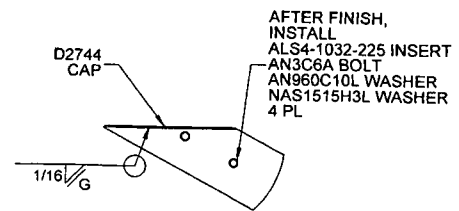
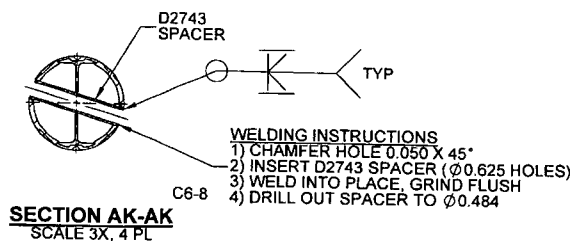
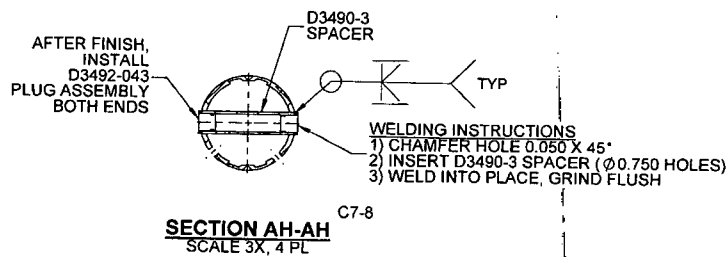
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D2750-041 350 SKIDTUBE ASSEMBLY, LH



DETAIL AG D8-8
SCALE 2X
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DESIGN	BA	DART AEROSPACE USA, INC. PORT HADLOCK, WA
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DE APPR.	AK	DRAWING NO. D2750
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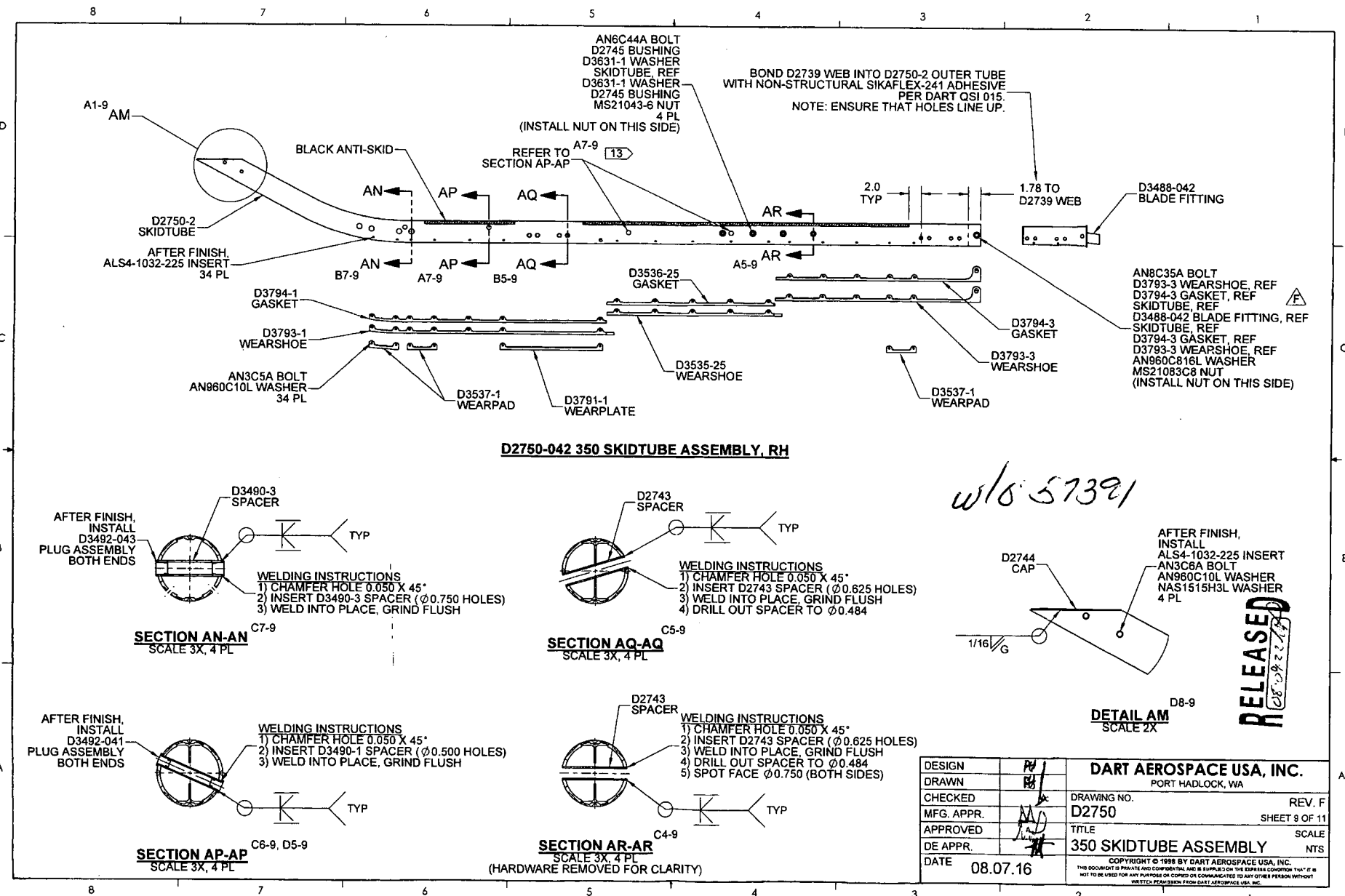
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



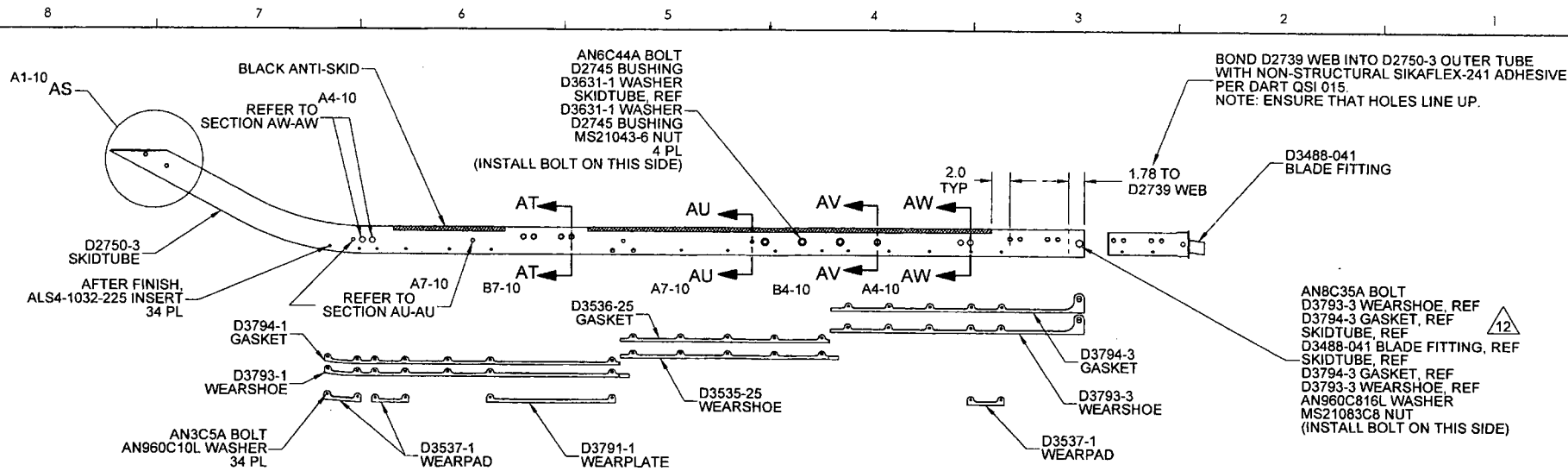
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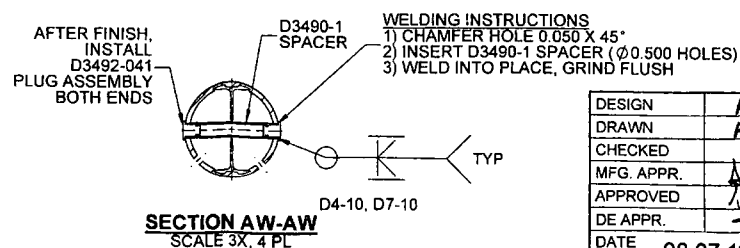
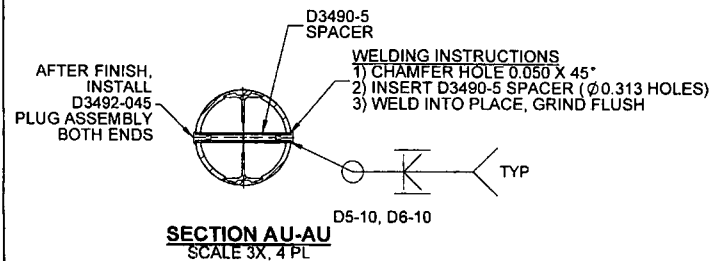
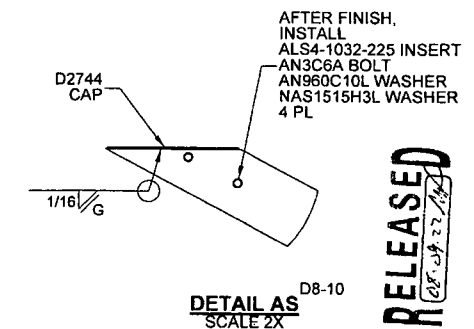
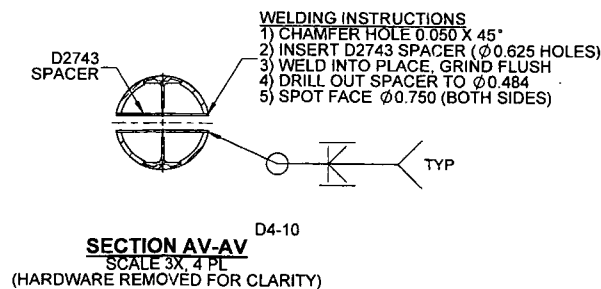
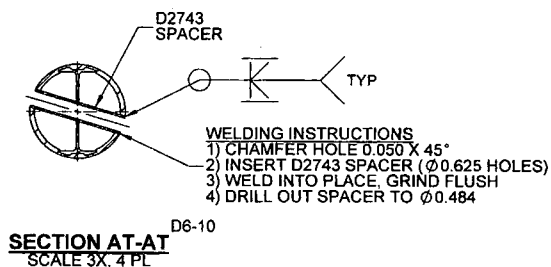
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH

w/o 51391



DESIGN		DART AEROSPACE USA, INC.
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CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. F
APPROVED		SHEET 10 OF 11
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DATE 08.07.16		SCALE NTS

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28 JUN 22 1994

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

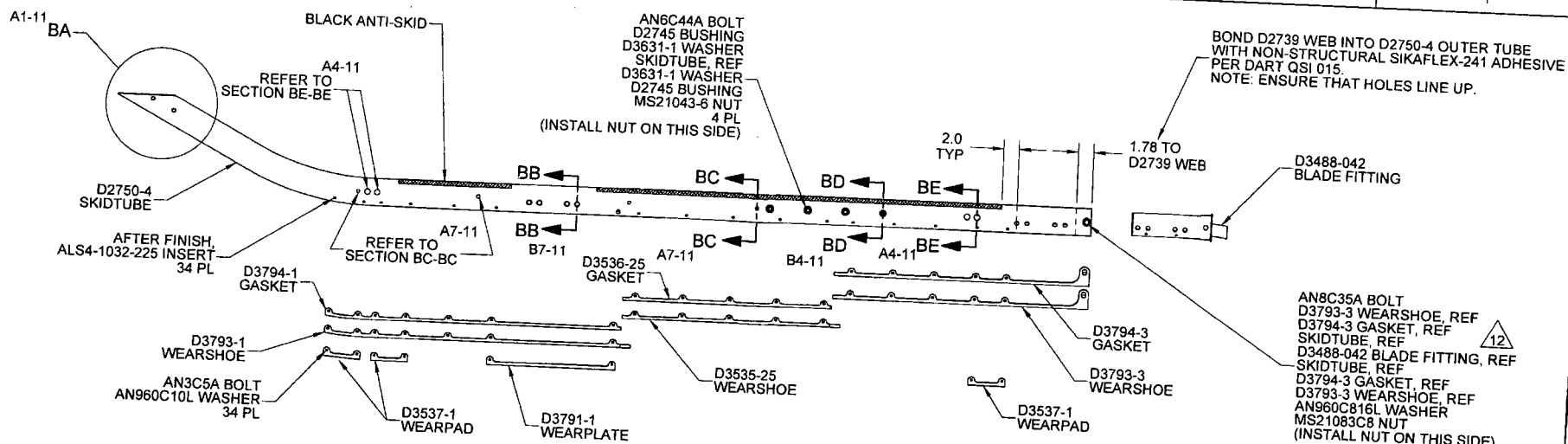
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

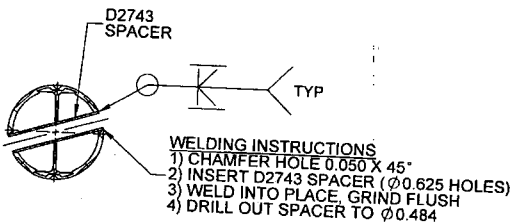
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

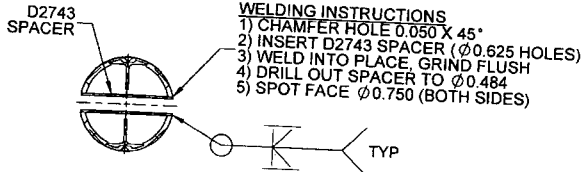
8 7 6 5 4 3 2 1



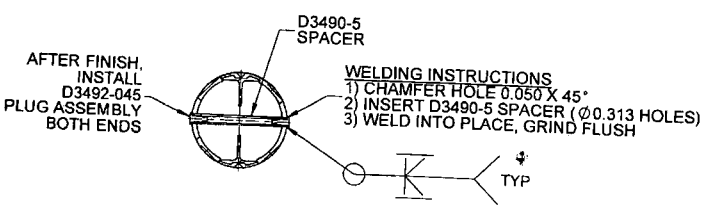
D2750-044 350 SKIDTUBE ASSEMBLY, RH



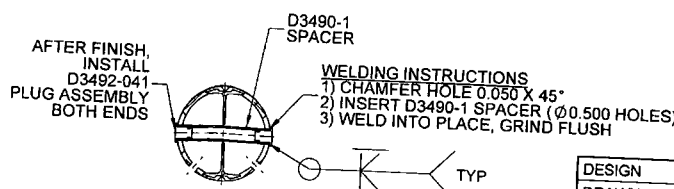
SECTION BB-BB
SCALE 3X, 4 PL



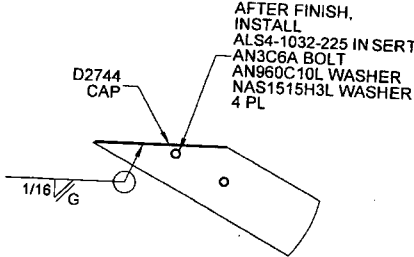
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN	HA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. F
DRAWN	HA		
CHECKED	HA		
MFG. APPR.	HA		
APPROVED	HA		
DE APPR.	HA	DRAWING NO.	D2750
DATE	08.07.16	TITLE	350 SKIDTUBE ASSEMBLY
		SHEET	11 OF 11
		SCALE	NTS

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RELEASED
06-09-22 / 11

W1057391

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 225

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Bardley Elliott
Job number: 56276
Part number: DSSC-636 013
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dalt. Date of Test Coupon 10.02.19

Welder Bardley Elliott Date of Test Coupon 10.02.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld